

Work Order ID 57284

March 31, 2010 1:03:16 PM

Page 1

Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 31/03/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-3-31

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

Sobles

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

110/121

57284.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M113207

BE 10/04/21

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

004

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M113207

BE 10/04/21

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64"
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

MB
10-04-22

Ph →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: sketches NCR: ☒ Yes No DQA: 100505 Date: 10/05/04
 Resolution: rework Disposition: rework QA: N/C Closed: 10/05/04 Date: 10/05/04

NCR: 57284		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/22	#140.7	when drilling APT cap hole take more care the hole to be elongated on aft.		Fill hole in with weld Per QST004 A/R MIL 3207 - Grind the welds flush inside and out	BE 10/04/22 MB 10-04-22			S 10/04/22
		R.L. sample to Pass		- Re drill in correct location BE MORE CAREFUL check	MB 10-04-22	S 10/04/22		G 10/04/22

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	81604/23						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	81604/23						
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							BR 10-4-26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date:	20/04/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 3:30pm								
190 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

1114207
10/04/26

1 9

D. Bl 10-4-27

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 M 112429

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with
Sikaflex. Clean excess adhesiveA/R ☐ ☐ ☐ Sikaflex-291 112429

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch M 113545

BK 10-4-27 ①

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041 Location: <u>B</u> PPP Rev: <u>1</u>								
230 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Subul28

④

10-5-35

10/05/04

Bf 10-5-04
①

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Work Order ID: 57284

Parent Item: D205-634-041

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Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 31/03/2010

Required Date: 20/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 6.0000 1.0000



205 Skidtube bent detail

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

6

54541

2

56975

2

57028

2

B57902 ① 10/04/21

D2576-3 Manufactured No 140 Each 120.0000 1.0000



Step (maching detail)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

120

46661

73

52215

47

1 815 10/04/21

Dart Aerospace Ltd

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IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 306.0000 20.0000



Crossbolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

306

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

51525

4

53780

3

54543

18

56715

2

56818

4

57052

153

20

BE 10/04/20

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 31/03/2010

Required Date: 20/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

132.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

1

56613

1

Main Warehouse

ST026

131

50513

1

50770

1

51539 ✓

35

53791

94

1 PR 10-4-27

AN3-5A

Purchased

No

200

Each

1,299.000

2.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

1299

100188

188

105057 ✓

1111

2 PR 10-4-27.

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Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

Purchased

No

200

Each

2,849.000 2.0000



Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

2849

101291

16

105793

49

110985 ✓

2784

ALS7-1032-130

Purchased

No

200

Each

886.0000 50.0000



Insert



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

886

108606

52

111529

130

111779

34

112772

11

113238

659

ALH-1032-130

50 PR 10-4-27.

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

889.0000

50.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350 114330 ✓

889

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

227

113644

12

113749

1

114103

54

114108

500

50 BR 10-4-27

AN960C10L

Purchased

No

200

Each

0.0000

50.0000



washer

NAS 1149C0332R

114341



50 BR 10-4-27

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 60.0000 1.0000



Gasket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 60

45717 1

50265 1

53461 ✓ 58

D3566-5 Manufactured No 200 Each 21.0000 1.0000



Gasket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 3

36113 1

46186 1

51260 1

Main Warehouse

FP015 13

56829 ✓ 13

Main Warehouse

FP19 5

55335 5

1 10-4-27

1 10-4-27

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Start Date: 31/03/2010

Required Date: 20/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 29.0000 2.0000



Gasket



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57257	10
46349	1
51218	1
51259	3
52512	3
54480	1
55011	1

Main Warehouse

FP015	19
56825	19

2 10-4-27

D3564-11 Manufactured No 200 Each 9.0000 1.0000



Wearshoe



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57259	2
45823	1
50112	1

Main Warehouse

FP19	7
56834	7

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 1:03:21 PM

Page 8

Work Order ID: 57284

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 31/03/2010

Required Date: 20/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

39.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

21

45409

2

46495

10

56285

9

Main Warehouse

FP17

18

56533 ✓

18

D3564-9

Manufactured No

200

Each

6.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

6

44659

1

55334

5

March 31, 2010 1:03:21 PM

Shop Packet Print

Page 8

1 *10-4-27.*

1 *10-4-27.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 1:03:21 PM

Page 9

Work Order ID: 57284



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 31/03/2010

Required Date: 20/04/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

20.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP

18

45824

1

55024

6

55333 ✓

11

D2594-3

Manufactured No

200

Each

318.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

318

51613

27

52562

13

55546 ✓

278

1 LR 10-4-27.

16 LR 10-4-27.

March 31, 2010 1:03:21 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 1:03:21 PM

Page 10

Work Order ID: 57284



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 31/03/2010

Required Date: 20/04/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

419.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

419

42221

16

42807

92

43884

3

46435

2

51527

9

51757

6

54008

1

54643

15

55002 ✓

275

16. BL 10-4-27

March 31, 2010 1:03:21 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.28 #

DESIGN #	DRAWN-BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

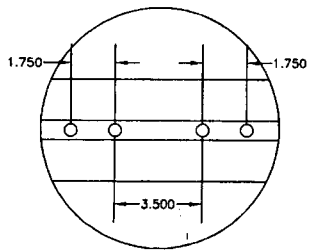
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57284

07-10-3-31

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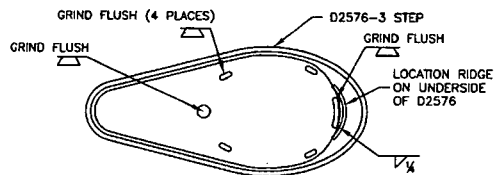
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DETAIL A
SCALE 5:24

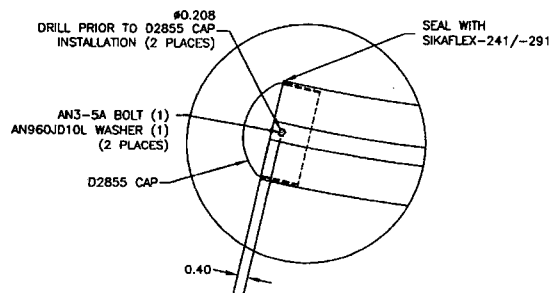


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07-06-28

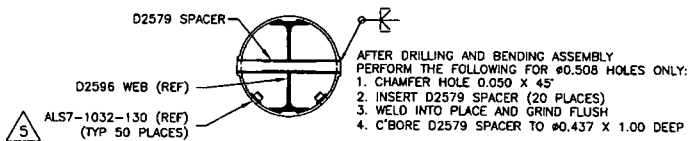
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



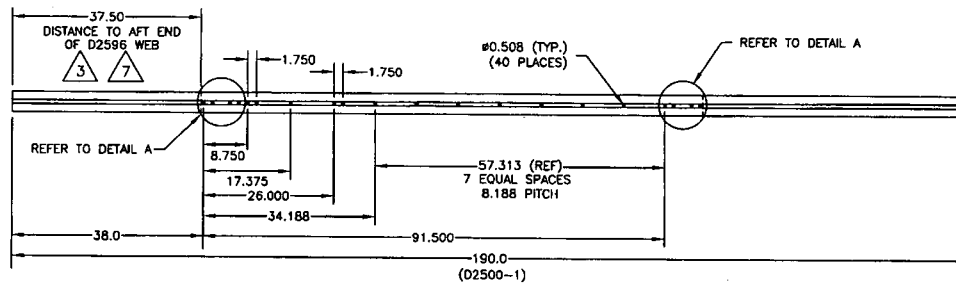
SECTION D-D
SCALE 5:24



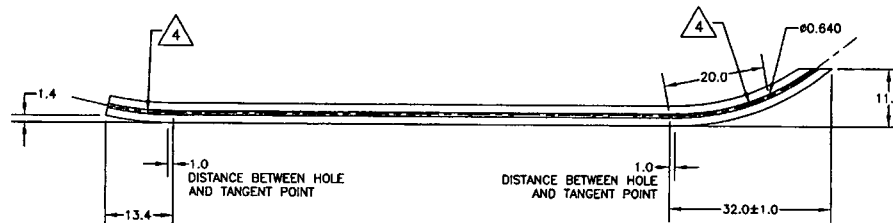
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

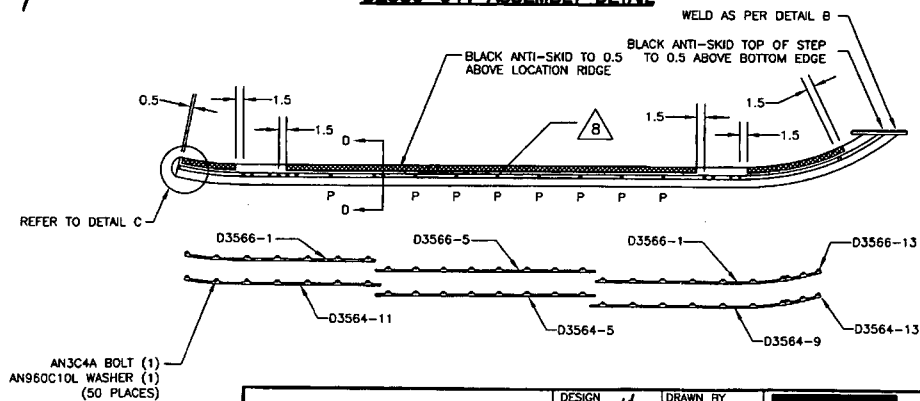
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	11
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CHECKED *41*

DATE _____

DRAWN BY

APPROVED/

DART

DRAWING NO.	
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D2580

[illegible]

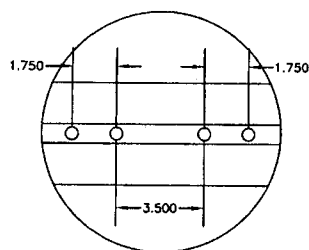
DART AEROSPACE LTD.
HAMKESBURY, ONTARIO, CANADA

REV. 0

SHEET 2 OF 3

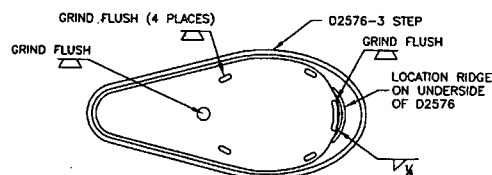
SCALE

DETAIL E
SCALE 5:24

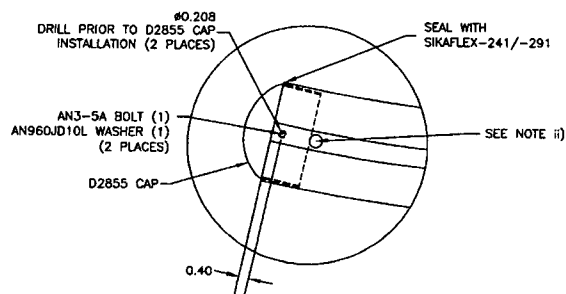


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07.06.88

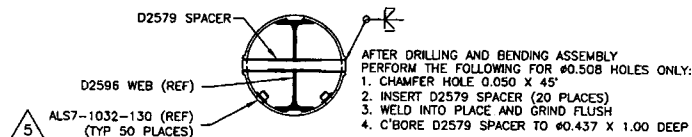
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SCALE 5:24



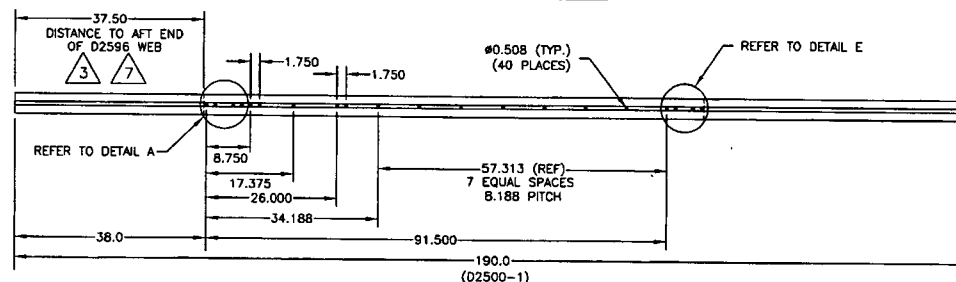
DETAIL G
SCALE 5:24



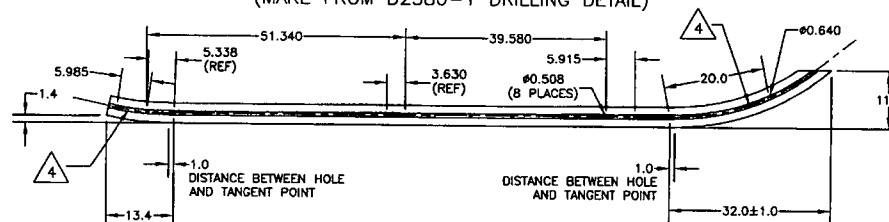
SECTION H-H
SCALE 5:24



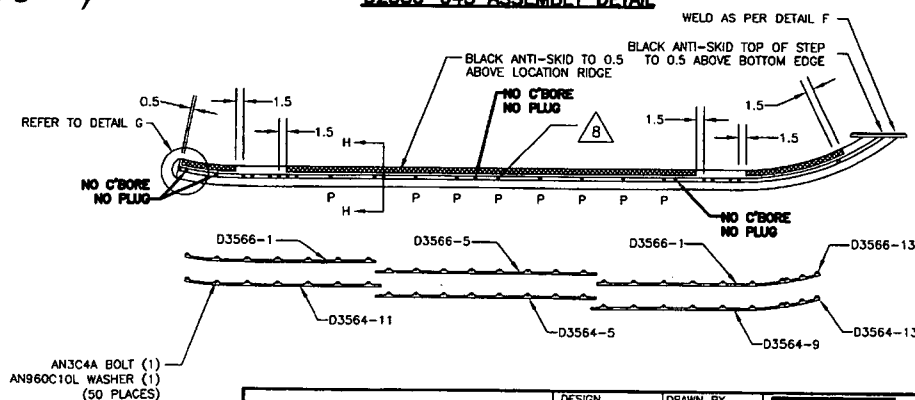
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



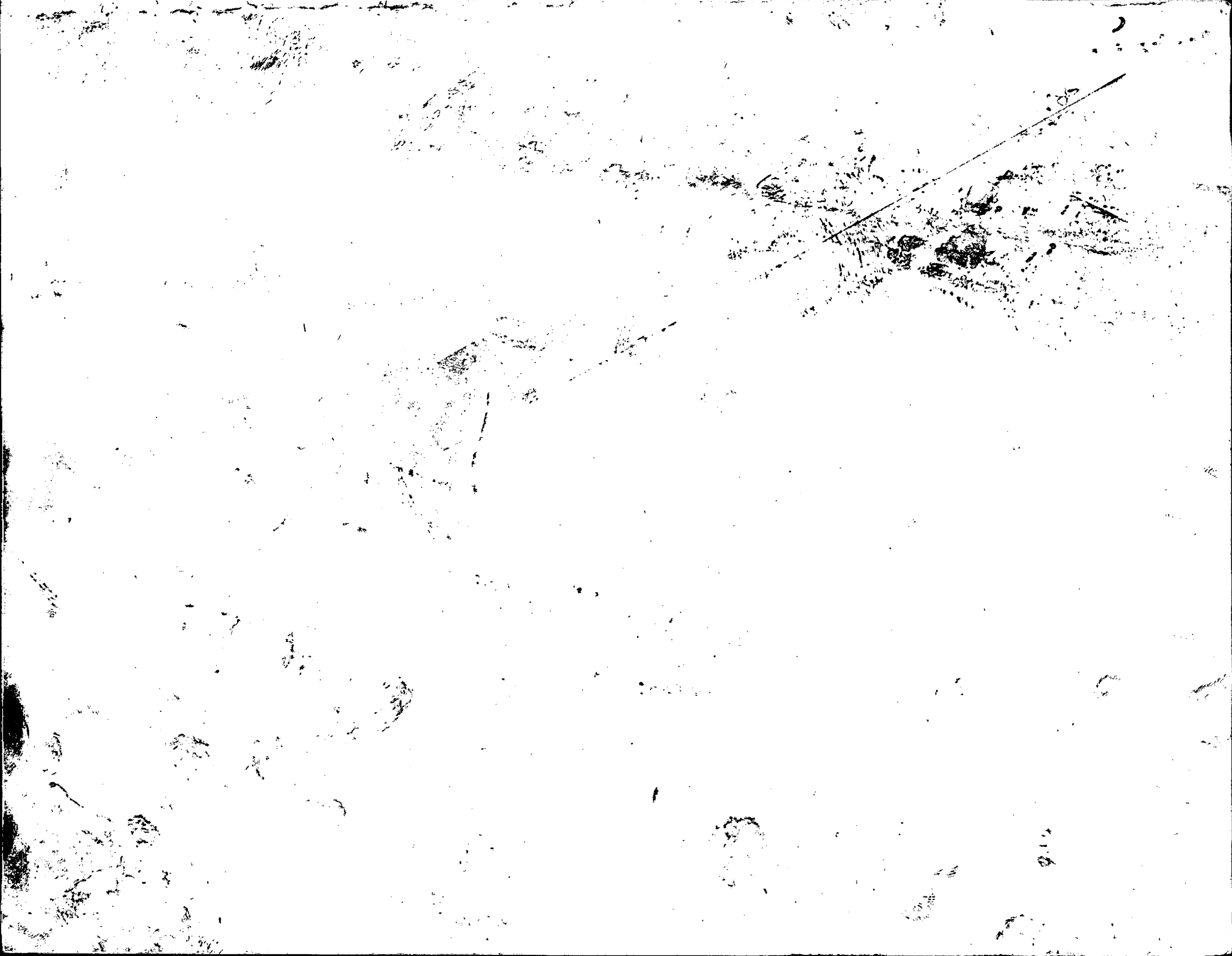
D2580-045 NOTES

- FINISH:** ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB. POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	REV. 0
CHECKED H	APPROVED H	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	



NO. 227

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 56925
Part number: D205-634-011
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Smith Date of Test Coupon 10-03-19

Welder Barday Elliott Date of Test Coupon 10-03-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld